

Work Order ID 63352

Wednesday, October 27, 2010 4:03:47 PM



Page 1

Item ID:	D3690-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Glareshield Assembly					
Start Date:	10/27/2010	Start Qty:	2.00			
Required Date:	11/11/2010	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:		Date:	10/10/28	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3690	Rev B								
100	Pick Kit	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
110	Small Fab	0.00							
	Small Fab								
	Small Fab								
	Memo	0.00							
	1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg								
	D3690□2- scribe bath # and part # as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							

2x

=> m.k 10/11/16

2x

=> m.k 10/11/17

12

8 10/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, October 27, 2010 4:03:51 PM

Page 1

Work Order ID: 63352

Parent Item: D3690-041

Parent Item Name: Glareshield Assembly



Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP Rev:C 08-09-08 added painting DD verified by:EC
IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD3  Washer		Purchased	No				Each	140.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST346				140					
				107989	✓			140					
CR3213-4-03  rivet		Purchased	No				Each	74.0000	35	70			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST312				74					
				19099				74					
D3690-1  Glareshield		Manufactured	No				Each	0.0000	1	2			
D3697-041  Tube Assembly		Manufactured	No				Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST241A				2					
				59243	✓			2					

B63373

m-p 10/11/16

4X

m-p 10/11/16

72X

✗

2X m-p 10/11/16

m-p 10/11/16

2X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, October 27, 2010 4:03:51 PM

Work Order ID: 63352



Parent Item: D3690-041



Parent Item Name: Glareshield Assembly

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 2.00

Required Qty: 2.00

D3698-1 Manufactured No

Each 6.0000 1 2



m-l 10/11/16

Support Angle

Location

Loc Qty

Loc Code

ST241A

6

59244 ✓

2x

MS20426AD3-14 Purchased No

Each 14,484.00 2 4



m-l 10/11/16

Rivet

Location

Loc Qty

Loc Code

ST316

14484

4179 ✓

2646

4444

5678

4533

6160

4x

**PTO*

PTO

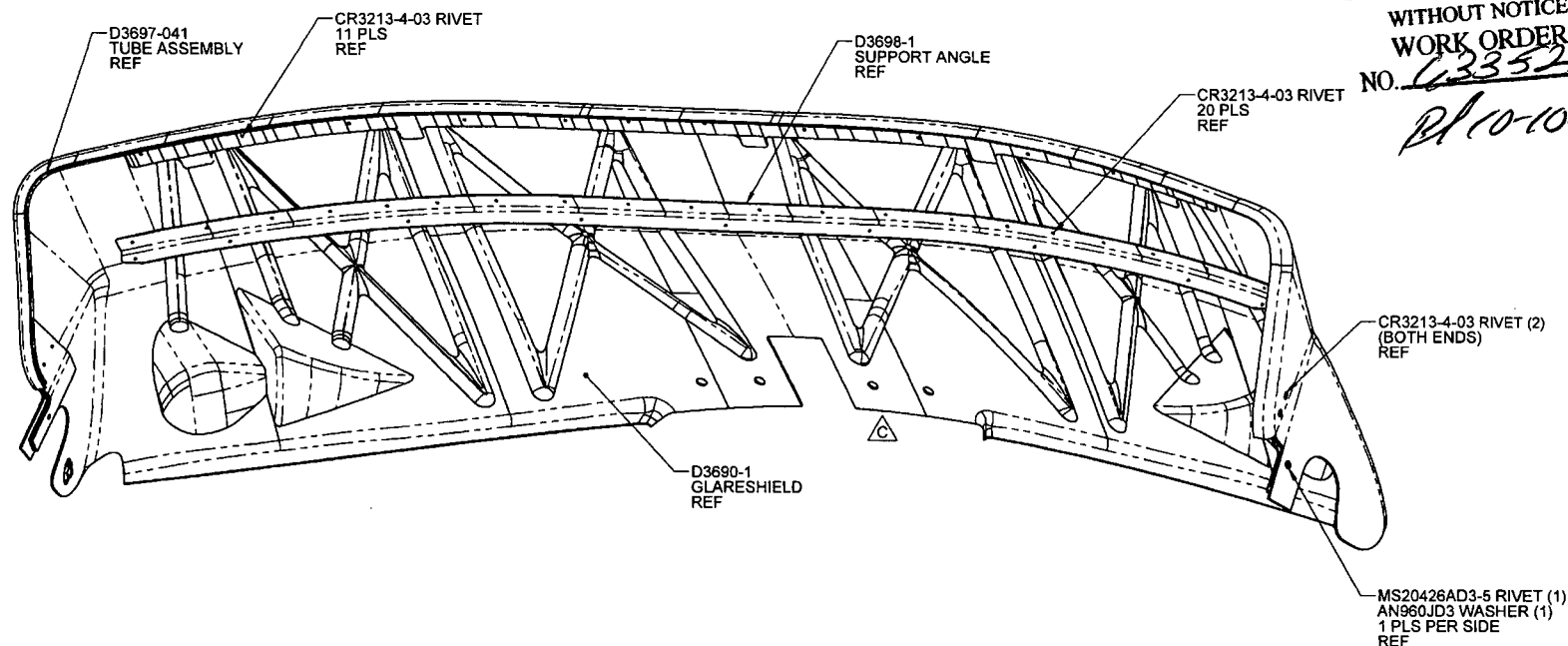
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3690-041 PAR #: _____ Fault Category: Small Rib ~~Thermoforming~~ NCR: (Yes) No DQA: [Signature] Date: 10/12/02
 Resolution: Acceptable Disposition: Use as is. QA: N/C Closed: [Signature] Date: 10/12/02

NCR: <u>63352</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.11.16	110	MS20426AD3-5 TOO LONG. R.C. PLASTIC AT MINIMUM TOLERANCE	<u>[Signature]</u> 10/11/16	ACCEPTABLE TO USE MS20426AD3-4 WHERE APPLICABLE. M 604374	<u>[Signature]</u> 10/11/17	<u>[Signature]</u> 10/11/18	<u>[Signature]</u> 10/11/16	<u>[Signature]</u> 10/11/18

NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63352
PL 10-10-21



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
2	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-5	RIVET
35	CR3213-4-03	RIVET

D3690-041 GLARESHIELD ASSEMBLY

C	SHEET 1 PL MS20426AD3-5 RIVET WAS MS20426AD3-4, CR3213-4-03 RIVET WAS MS20470AD3-4, WASHER QTY WAS 6 (VIEWS UPDATED ACCORDINGLY). RIVETS ON SHEET 1 CHANGED TO REF QTY. RIVETS ON SHEET 2 CHANGED TO "HARD" CALLOUTS. SHADING REMOVED FROM ALL VIEWS FOR CLARITY.	AJS	08.09.02
B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A,8 & C,5; ADD MIN THICKNESS. SHEET 3 ZONE A,8	RF	08.08.24
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. C D3690 SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>	TITLE SCALE GLARESHIELD ASSEMBLY NTS	
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

△ TRANSFER DRILL Ø0.128
FROM D3698-1 TO D3690-1
INSTALL
CR3213-4-03 RIVET, 20 PL
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

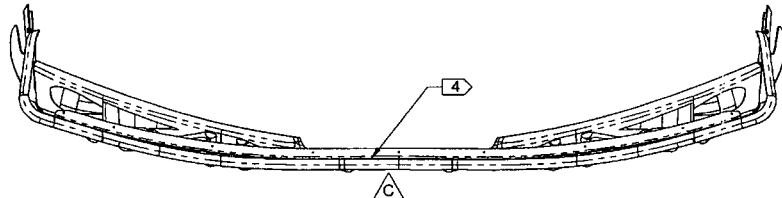
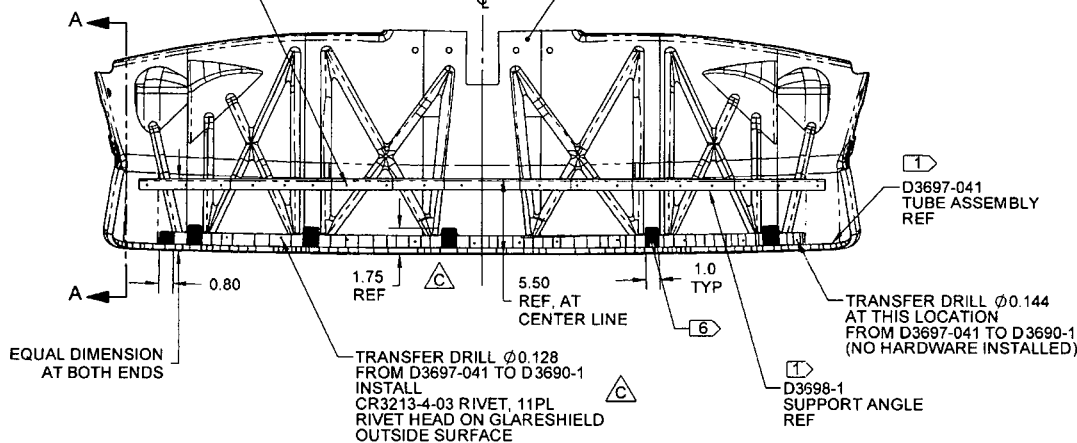
TRANSFER DRILL Ø0.098
FROM D3697-041 TO D3690-1
INSTALL
MS20426AD 3-5 RIVET
AN960JD3 WASHER (ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL Ø0.128
FROM D3697-041 TO D3690-1
INSTALL
CR3213-4-03 RIVET 2
BOTH ENDS

0.14
REF

SECTION A-A

uol 63352



D3690-041 GLARESHIELD ASSEMBLY

- NOTES:
- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
 - 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
 - 5) WEIGHT: 2.98 lbs
 - 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING

RELEASED
08-09-11

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
DATE	08.09.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

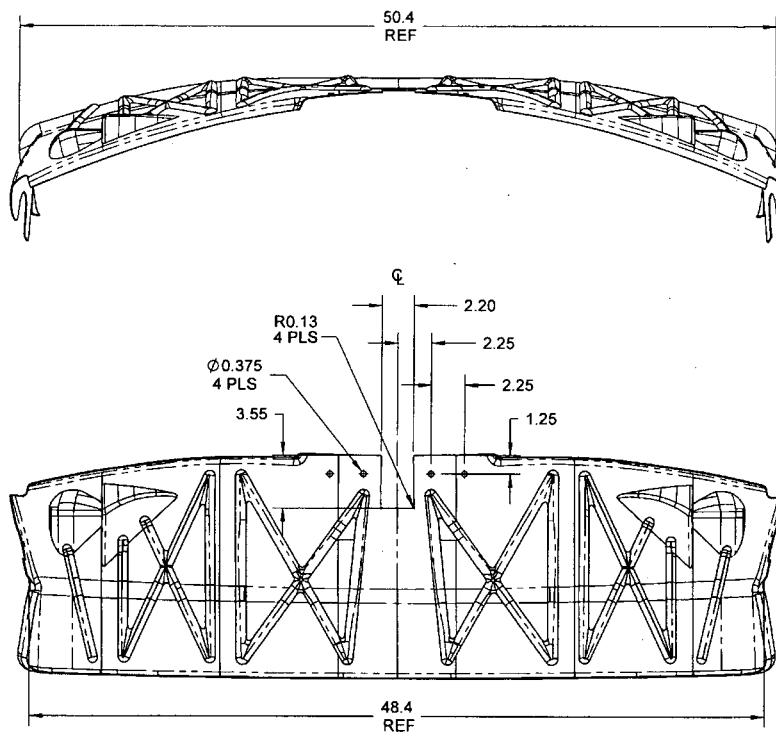
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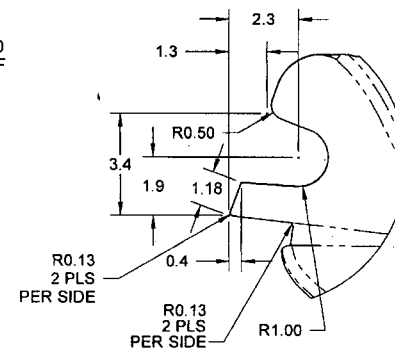
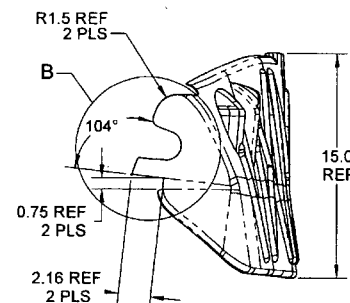
NOTE: Date & initial all entries



D3690-1 GLARESHIELD

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040



RELEASED
08.09.02

DETAILS
SCALE 2X
THIS VIEW FOR REFERENCE ONLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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